

Date: Thursday, 5/3/2007 11:30:08 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number : 32165	
Estimate Number : 10530	
P.O. Number : <i>N/A</i>	Part Number : D2571
This Issue : 5/3/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2571 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : <i>E</i>
Previous Run : 32076	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 5/25/2007 Qty: 12 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
7075-T7351 8.25X7.75X2.5
Make from D6101-007 billet for D2571
Ensure that grain is along 7.75" length
Batch No: *B25353*

ML 07/06/06

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No: *32165* Double check by: *BL*

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

ML/ES 07/06/10

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2571 & D2572

ML/ES 07/06/10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ML/ES 07/06/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 21/06/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/3/2007 11:30:08 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 32165

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.06.12

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MS

07-06-12 (12)

7.0

POWDER COATING

POWDER COATING



M 104144



(12)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR/M 07-06-18

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FD

07/06/18

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/06/18 (12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

07/06/19

Job Completion



U 07.06.19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

0.538

DART AEROSPACE LTD	Work Order: 32165
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1.

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.745	1.748	1.746	1.747		
C	3.495	3.505		3.498	3.500	3.500	3.499		
D	1.745	1.755		1.745	1.748	1.746	1.747		
E	7.990	8.010		8.002	8.002	8.003	8.003		
F	0.490	0.510		0.497	0.499	0.499	0.503		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.496	0.501	0.501	0.502		
J	1.174	1.184		1.175	1.175	1.175	1.178		
K	0.558	0.578		0.565	0.563	0.565	0.570		
L	1.174	1.184		1.175	1.175	1.175	1.178		
M	1.490	1.500		1.495	1.494	1.495	1.494		
N	2.495	2.505		2.497	2.497	2.496	2.499		
O	3.869	3.879		3.870	3.871	3.873	3.871		
P	0.115	0.135		0.125	0.125	0.125	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.249	0.249	0.249		
S	0.115	0.135		0.126	0.129	0.127	0.131		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.232	0.234	0.237	0.239		
W	0.115	0.135		0.125	0.122	0.123	0.131		
X	0.308	0.313		0.310	0.309	0.309	0.309		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.359	0.364	0.364	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.629	0.628	0.634		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.245	0.248	0.248		
AE	1.375	1.395		1.388	1.388	1.387	1.387		
AF	0.115	0.135		0.135	0.135	0.135	0.125		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.245	0.244	0.247	0.248		
AI	2.000	2.020		2.003	2.004	2.002	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: E	
Date: 07/06/08	

Audited by: S.A.	
Date: 07.06.08	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	32165
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.439	0.439	0.439	0.439		
B	1.745	1.755		1.748	1.748	1.748	1.749		
C	3.495	3.505		3.499	3.499	3.499	3.500		
D	1.745	1.755		1.748	1.749	1.748	1.749		
E	7.990	8.010		8.000	7.999	8.001	8.000		
F	0.490	0.510		0.504	0.504	0.505	0.506		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.501	0.501	0.501	0.502		
J	1.174	1.184		1.179	1.178	1.178	1.179		
K	0.558	0.578		0.569	0.570	0.569	0.570		
L	1.174	1.184		1.179	1.178	1.179	1.179		
M	1.490	1.500		1.495	1.494	1.494	1.495		
N	2.495	2.505		2.500	2.499	2.499	2.500		
O	3.869	3.879		3.871	3.871	3.871	3.871		
P	0.115	0.135		0.124	0.127	0.126	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.249	0.248	0.248		
S	0.115	0.135		0.131	0.132	0.131	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.966	2.966	2.966	2.966		
V	0.230	0.250		0.239	0.238	0.238	0.237		
W	0.115	0.135		0.130	0.129	0.130	0.129		
X	0.308	0.313		0.309	0.310	0.309	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.365	0.365	0.365	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.506		
AB	0.615	0.635		0.621	0.631	0.630	0.631		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.247	0.246	0.246		
AE	1.375	1.395		1.387	1.388	1.386	1.387		
AF	0.115	0.135		0.126	0.136	0.130	0.130		
AG	0.240	0.280		0.266	0.256	0.255	0.255		
AH	0.240	0.260		0.248	0.247	0.249	0.246		
AI	2.000	2.020		2.002	2.003	2.000	2.001		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	cmk
Date:	07/06/09

Audited by:	SN
Date:	07.06.12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	32165
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Inspection Dwg: D2571 Rev. E		Page 1 of 1

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B	1.745	1.755		1.749	1.748	1.749	1.749		
C	3.495	3.505		3.500	3.499	3.499	3.499		
D	1.745	1.755		1.749	1.748	1.749	1.749		
E	7.990	8.010		8.000	7.999	8.001	8.001		
F	0.490	0.510		0.502	0.504	0.503	0.503		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.501	0.500	0.506	0.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.569	0.570	0.570	0.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.494	1.495	1.495	1.495		
N	2.495	2.505		2.499	2.500	2.499	2.500		
O	3.869	3.879		3.872	3.872	3.872	3.872		
P	0.115	0.135		0.126	0.126	0.125	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.248	0.249	0.249		
S	0.115	0.135		0.130	0.131	0.128	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.966	2.960	2.960	2.960		
V	0.230	0.250		0.236	0.235	0.235	0.235		
W	0.115	0.135		0.127	0.129	0.129	0.129		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.364	0.365	0.364	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.506		
AB	0.615	0.635		0.632	0.632	0.631	0.632		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.244	0.245	0.245		
AE	1.375	1.395		1.388	1.387	1.388	1.388		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.245	0.245	0.247	0.245		
AI	2.000	2.020		2.002	2.001	2.002	2.001		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	<i>SM</i>
Date:	07/06/10

Audited by:	<i>SD</i>
Date:	07.06.12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>SM</i>

RELEASED

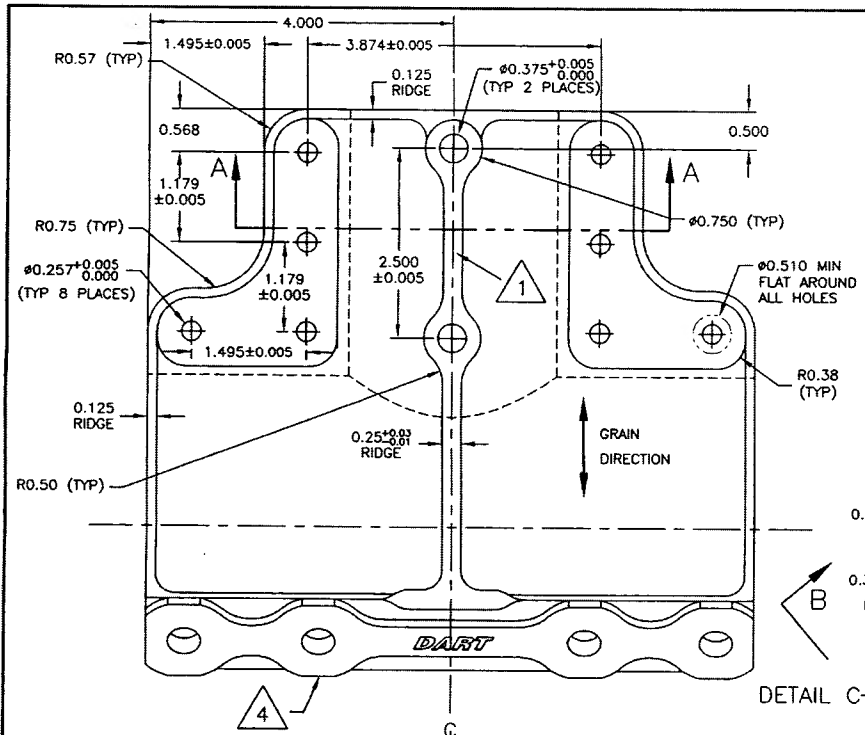
05.12.06

NOTES

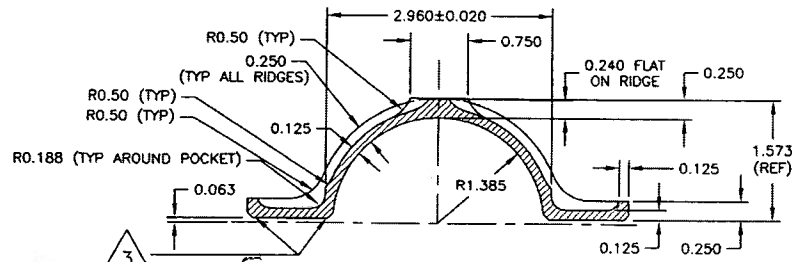
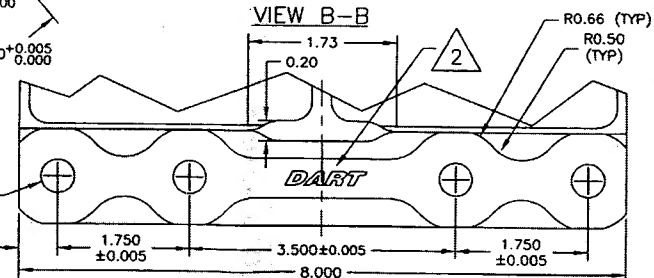
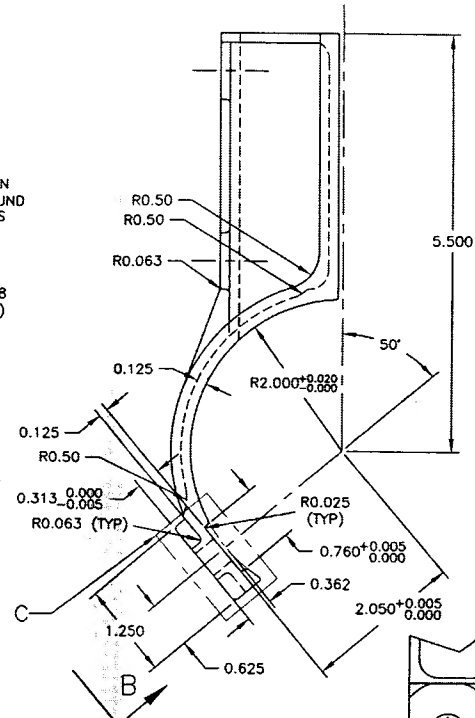
MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

E



DETAIL C



SECTION A-A

DETAIL C
 SCALE 4:3

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E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	TITLE
		OUTER FWD SADDLE

DART DART AEROSPACE LTD.
 HANESSBURY, ONTARIO, CANADA

DRAWING NO. D2571
 SHEET 1 OF 1
 SCALE 2:3

NO. 13165
 WORK ORDER
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 UNCONTROLLED COPY
 ENGINEER'S
 RETURN TO
 SHOP COPY
 NO. 13165